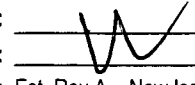
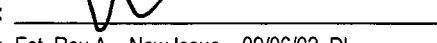


Date: Thursday, 18/06/2009 10:01:07 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HAT BIN, 206A/B, W/LITTTER, GREY
Job Number : 48636A	
Estimate Number : 13973	
P.O. Number :	Part Number : D38243KGY
This Issue : 18/06/2009 S.O. No. :	Drawing Number : D3824-3
Prsht Rev. : NC	Project Number :
First Issue : / / Type : THERMOFORMING	Drawing Revision :
Previous Run :	Material : MYKD6185S125P352068
Written By : 	Due Date : 24/06/2009 Qty: 1 Um: Each
Checked & Approved By : 	
Comment : Est. Rev A New Issue 09/06/02 DL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	MKYD6185S125P352068	6185 Kydex 125" steel grey
-----	---------------------	----------------------------



Comment: Qty.: 11.4144 sf(s)/Unit Total : 11.4144 sf(s)
6185 Kydex .125" Grey *M 111807*

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------



Comment: HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/06/18 (X1)

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------



Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/06/18

4.0	THERMOFORMING	THERMOFORMING MACHINE
-----	---------------	-----------------------



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3824-3 and folio FTA 034 using tool DT 9448

Dwg. Rev. 
Folio Rev. 

BB 09/06/18 (X1)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/06/18 (X1)

Date: Thursday, 18/06/2009 10:01:08 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HAT BIN, 206A/B, W/LITTER, GREY

Job Number: 48636A

Part Number: D38243KGY

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



(X1)

Comment: SECOND CHECK

Wh 09/06/18

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



(X1)

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

Wh 09/06/18

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(X1)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

Wh 09/06/18

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 07/06/23 (X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

IN THERMOFORMING.
HELD FOR PACKAGING Wh

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/23 (X)

Job Completion



mf 09-06-23

DART AEROSPACE LTD		Work Order:	48636A
Description: HAT Bin, 706A/B, w/Litter Tray		Part Number:	D3824-31664
Inspection Dwg:	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: Wh

Date: 09/06/18

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.43	± 0.05	0.432	✓			
48.5	Ref	48.375	✓			
34.1	Ref	33.7	✓			
41.6	Ref	41.6	✓			
3.5	Ref	3.375	✓			
0.055	MIN.	0.105	✓			

Measured by: Wh

Date: 09/06/18

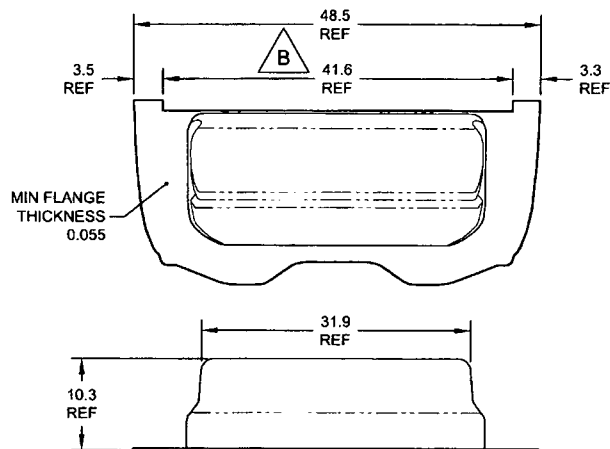
Audited by: S

Date: 09/06/18

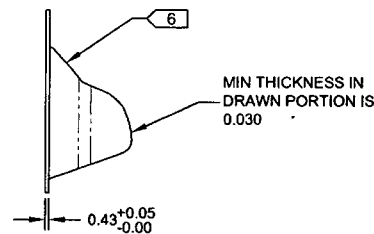
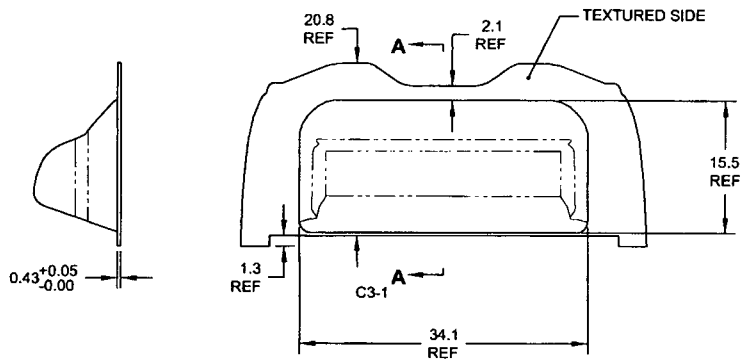
Prototype Approval: n/n

Date: n/n

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



SECTION A-A
SCALE 2X



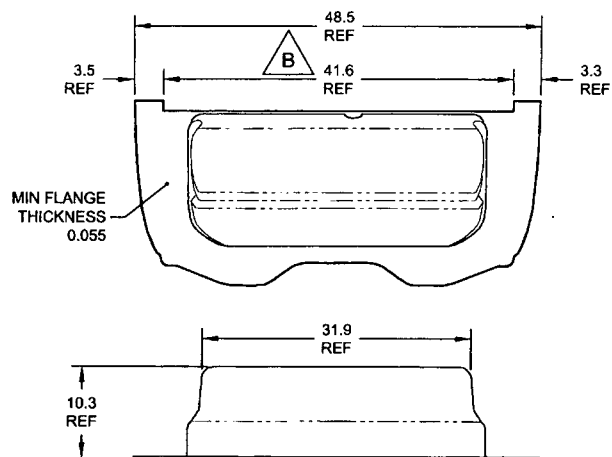
D3824-1 HAT BIN
(BELL 206 A/B)

NOTES:

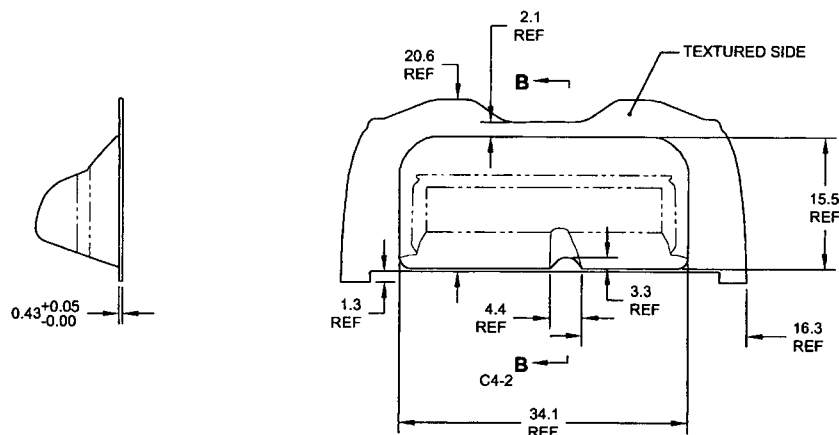
- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 5.6 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9405 PER DART QSI 022. TRIM PER MOLD

PART NUMBER	DESCRIPTION
D3824-1KIV	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3824-1KGY	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N'S D3824-1KIV, D3824-3KIV AND ADD STEEL GRAY P/N'S D3824-1KGY, D3824-3KGY (ZN A5-1, A5-2)	PH	09.05.05
B	0.125 THICK WAS 0.080 (ZN A7-1, A7-2) REASON: TO IMPROVE DURABILITY; MODIFY WIDTH TO ALLOW FOR BETTER FIT WITH A/C (ZN D6-1, D6-2)	PH	09.02.19
A	NEW ISSUE	PH	08.10.01
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PA		
CHECKED	PA	DRAWING NO.	REV. C
MFG. APPR.	PA	D3824	SHEET 1 OF 2
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	HAT BIN (BELL 206 A/B)	NTS
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SECTION B-B
SCALE 2X



D3824-3 HAT BIN
(BELL 206 A/B, LITTER KIT COMPATIBLE)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 5.6 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9448 PER DART QSI 022. TRIM PER MOLD

PART NUMBER	DESCRIPTION
D3824-3KIV	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3824-3KGY	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	PA	DART AEROSPACE LTD
DRAWN	PA	HAWKESBURY, ONTARIO, CANADA
CHECKED	PA	DRAWING NO. REV. C
MFG. APPR.	PA	D3824 SHEET 2 OF 2
APPROVED	PA	TITLE SCALE
DE APPR.	PA	HAT BIN (BELL 206 A/B) NTS
DATE	09.05.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD
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